

Slip 16/07

Dart Aerospace Ltd.

Date: Thursday, 7/12/2007 10:39:26 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR DOUBLER
Job Number	: 33522		
Estimate Number	: 12680		
P.O. Number	: N/A	Part Number	: D3594041
This Issue	: 7/12/2007 S.O. No. : N/A	Drawing Number	: D3594 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 31508	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 7/17/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	4 Um: Each
Comment	: Est Rev : A New Issue 07-01-22 EC		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet

Comment: Qty.: 0.0578 sf(s)/Unit Total : 0.2310 sf(s)  
6061-T6 .080 Sheet  
Batch: M104921 HB 07-07-13

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

Comment: FLOW WATER JET  
1-Cut as per Dwg D3594  
Dwg Rev: A  
Prog Rev: A

2-Deburr if necessary

HB 07-07-13

SAD

07/07/16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/07/16 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
C'SINK AS [PER dwg d3594]

SAD 07/07/16

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/12/2007 10:39:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 33522

Part Number: D3594041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



checked with  
Rivet for count  
6/mk

Comment: INSPECT WORK TO CURRENT STEP

En 07/07/16 (4)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mf 07/07/16

(4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf

07-07-17

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Anchor nuts

Batch: m104214 -

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch: m1021 -

mf 07-07-17

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D3594

mf

07-07-17

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/17 (4)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/7/17 SP

(4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 8/15/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/12/2007 10:39:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 33522

Part Number: D3594041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.17  
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

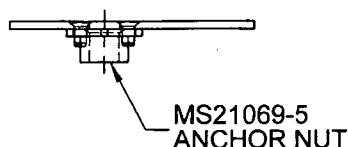
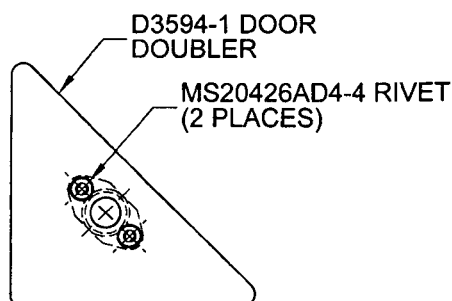
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

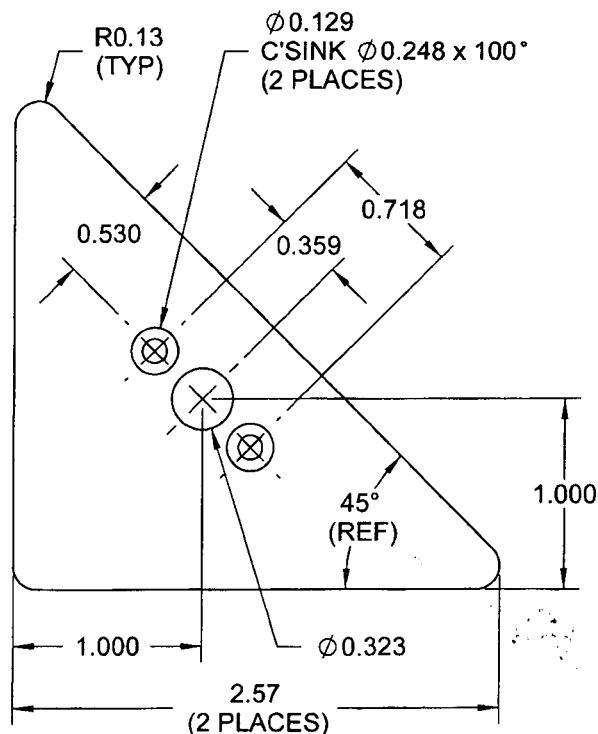
**NOTE:** Date & initial all entries

**DART****RELEASED**  
07.07.11  
Per G.W. Hackett

DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3594</b>	REV. A SHEET 1 OF 3
DATE <b>07.04.13</b>	TITLE <b>DOUBLER</b>	SCALE 1:1	
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3594-041 DOOR DOUBLER ASSEMBLY**   
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET

**D3594-1 DOOR DOUBLER**

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WITHOUT NOTICE  
WORK ORDER  
NO. **33522**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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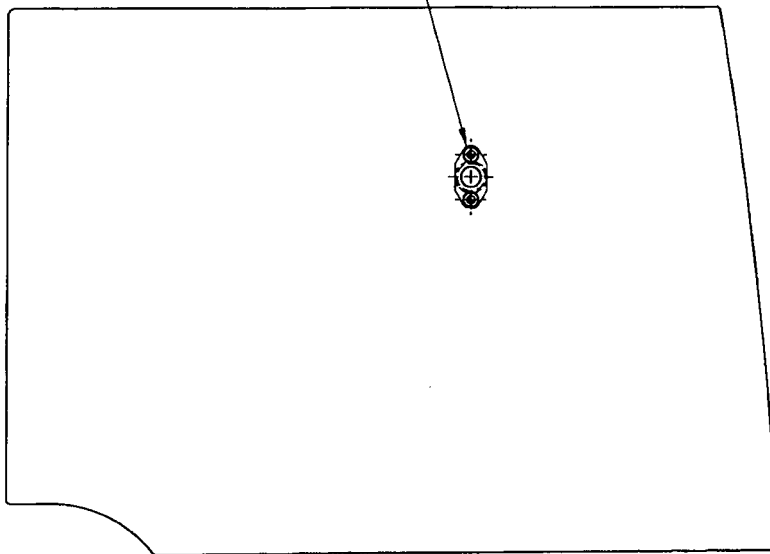


DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3594</b>	REV. A SHEET 2 OF 3
DATE <b>07.04.13</b>		TITLE <b>FLOOR DOUBLER ASSEMBLY</b> SCALE 1:3	

**RELEASED**  
07.07.11 *H*

Per 604 #1021

MS20426AD4-4 RIVET  
(2 PLACES)



MS21069-5  
ANCHOR NUT



D3594-3 FLOOR DOUBLER (D3594-043)  
D3594-4 FLOOR DOUBLER (D3594-044)

**D3594-043 FLOOR DOUBLER ASSEMBLY**  
**(D3594-044 OPPOSITE)**

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

**NOTES:**

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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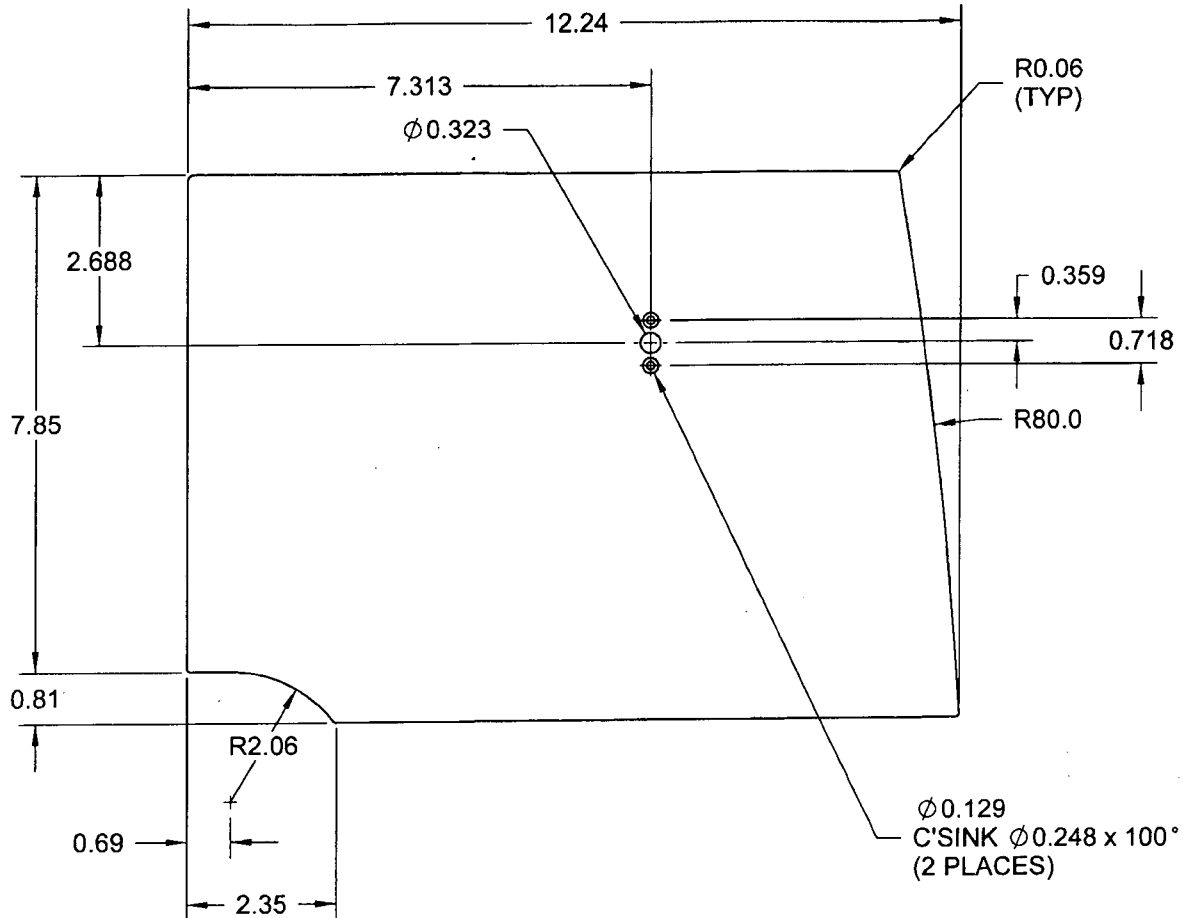


DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. <b>D3594</b>	REV. A SHEET 3 OF 3
DATE <b>07.04.13</b>		TITLE <b>DOUBLER</b>	SCALE 1:3

**RELEASED**

07.07.11 13

PER 6041601



**D3594-3 FLOOR DOUBLER**  
**(D3594-4 OPPOSITE)**

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